

# Work Order ID 63796

Monday, November 15, 2010 8:30:52 AM



Page 1

Item ID: D350-578-011

Accept



Setup Start



Revision ID:

Stop



Item Name: Bearpaw

Start Date: 11/12/2010 Start Qty: 8.00



Cust Item ID:

Required Date: 11/19/2010 Req'd Qty: 8.00



Customer:

Reference:

Approvals: Process Plan: *N*

Date: *10-11-15* Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
<b>Draw Nbr</b>	<b>Revision Nbr</b>								
D2432	Rev F3								
100	DOCUMENT CONTROL	0.00							
DC	Memo	0.00							
Document Control	Photocopy bluefile and create labels per PPP D350-578-011 CHG005								
160	Pick Kit	0.00							
Packaging	Memo	0.00							
Packaging									
170	QC4- 100% Inspect kits for completeness	0.00							
QC	Memo	0.00							
Quality Control									

*ACK for BG 10/11/17*

*8/10/17*

*10/11/17 ex sf*

*8/10/17*

*ES*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

**Work Order ID 63796**

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Item ID: D350-578-011

Accept

Setup Start

Revision ID:

Stop

Item Name: Bearpaw

Start Date: 11/12/2010 Start Qty: 8.00

Cust Item ID:

Required Date: 11/19/2010 Req'd Qty: 8.00

Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Run Start

QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

180

0.00



Packaging

Packaging

Memo

0.00

Packaging

Identify and pack for shipping as per PPP D350-578-011 Location: 11

Rev A

11/15/10 (S)

190

0.00



QC

QC21- Final Inspection - Work Order Release

Memo

0.00

Quality Control

11/11/10 (S)  
B/10-11-10  
(S)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Picklist Print

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Work Order ID: 63796

Parent Item: D350-578-011

Parent Item Name: Bearpaw



Start Date: 11/12/2010

Required Date: 11/19/2010

Start Qty: 8.00

Required Qty: 8.00

Comments: IPP Rev:A New Issue 07-01-02 JLM  
IPP Rev:B 08-01-09 Added Step 2 JLM Verified By:EC  
IPP Rev:C 08-10-15 New Manufacturing Method JLM Verified By:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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AN4-17A 		Purchased	No			160	Each	410.0000	12	96		10/11/17	
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878 Bolt

Location Loc Qty Loc Code

ST359 410

112314 410

D2182B 		Manufactured	No			160	f	393.2859	2.5	20		10/11/17	
------------	--	--------------	----	--	--	-----	---	----------	-----	----	--	----------	--

Rubber Cushion

Location Loc Qty Loc Code

ST410 393.28594

52649 43.28594

63413 350

Cut qty 6 at 5.00" long

D2274 		Manufactured	No			160	Each	397.0000	12	96		10/11/17	
-----------	--	--------------	----	--	--	-----	------	----------	----	----	--	----------	--

Radius Block

Location Loc Qty Loc Code

ST010 397

59108 4

61361 78

62658 315

A verification  
MEL our  
want  
me back

878  
→ replace  
8.10.11/17

14x  
54x

10/11/17

45x  
51x

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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# Picklist Print

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Work Order ID: 63796

Parent Item: D350-578-011

Parent Item Name: Bearpaw

Start Date: 11/12/2010

Required Date: 11/19/2010

Start Qty: 8.00

Required Qty: 8.00

Sfb D2432  
206 (24") Bearpaw

Manufactured No 160 Each 3.0000

2 16



62681 15X6

## Location

## Loc Qty

## Loc Code

ST495

3

52526

1

63279

2

52526

Sfb D2438  
Clamp

Manufactured No 160 Each 179.0000

6



48  
10/11/175

## Location

## Loc Qty

## Loc Code

ST456

179

60852

179

96  
10/11/175

Sfb D2529  
Washer

Manufactured No 160 Each 481.0000

12



96  
10/11/175

## Location

## Loc Qty

## Loc Code

ST017

481

61979

481

96

Sfb MS21042L4  
Nut

Purchased No 160 Each 2,556.000

12



96  
10/11/175

## Location

## Loc Qty

## Loc Code

ST300

2556

113422

25

114523

8

115589

1423

115621

1100

96

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Shop Packet Print

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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Work Order ID: 63796

Parent Item: D350-578-011

Parent Item Name: Bearpaw



Start Date: 11/12/2010

Required Date: 11/19/2010

Start Qty: 8.00

Required Qty: 8.00

NAS1149D0463J

Purchased

No

160

Each

1,619.000

24

192



Washer



10/11/17 SP (E)

## Location

## Loc Qty

## Loc Code

ST298

1619

10096

10

114576

68

115622

45

116025

1496

192

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

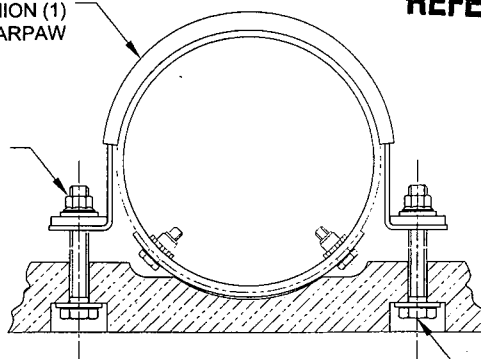
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**NOTE:** Date & initial all entries

D2438 CLAMP (1)  
D2182B050 RUBBER CUSHION (1)  
3 PL PER BEARPAW

REFERENCE ONLY

MS21042L4 NUT (1)  
AN960JD416 WASHER (1)  
D2274 RADIUS BLOCK (1)  
D2529 WASHER (1)  
AN4-17A BOLT (1)  
6 PL PER BEARPAW



ADDITIONAL AN960JD416 WASHERS MAY BE INSTALLED UNDER THE NUTS TO ENSURE 1.5-4 THREADS IN SAFETY ON THE BOLTS. ALTHOUGH NOT GENERALLY NECESSARY, IT IS ALSO ACCEPTABLE TO REPLACE THE AN4 BOLTS PROVIDED WITH LONGER OR SHORTER AN4 BOLTS, IF REQUIRED.

Section A-A  
Figure 4 - Clamping Detail

## 5.0 PARTS LIST

Qty -011	Qty -021	Part Number	Description
X		D350-578-011	BEARPAW INSTALLATION
	X	D350-578-021	BEARPAW INSTALLATION
6	6	D2182B050	Rubber Cushion
12	12	D2274	Radius Block
12	12	D2529	Washer
6	6	D2438	Clamp
2		D2432F	Bearpaw
	2	D2672F	Bearpaw
12	12	AN4-17A	Bolt
24	24	AN960JD416	Washer
12	12	MS21042L4	Nut (or MS21042-4)